November 18, 2009 12:38:42 PM Accept D2230-3 Item ID: Setup Start Revision ID: Stop Item Name: A Start Date: Start Qty: 120.00 18/11/2009 **Cust Item ID:** Required Date: 25/11/2009 Req'd Qty: 120.00 **Customer:** Reference: Start Run Tooling: Date: Approvals: Stop SPC (Y/N): Date: QC: Date: Reject Plan Accept Reject Insp. Sequence ID/ Operation Set Up/ Draw Draw Run Hours Number Qty Qty Number Stamp Rev. Code Work Center ID Description **Revision Nbr** Draw Nbr D2230 Rev F 0.00 100 **BAND SAW** 120 onf 09/11/22 0.00 Bandsaw Memo Band Saw || Cut D2423 extrusion to 0.82" || Batch: 43722 Jeaspa Bandsaw 0.00 110 HAAS CNC VERTICAL MACHINING #1 0.00 HAAS 1 Machine per folio D2230-3 Check for crack while loading into the machine c9/12/63 HAAS CNC vertical machine #1 OFP09/12/01 0.00 QC2- Inspect parts off machine FAI/FAIB 120 0.00 Memo Quality Control

Dart Aerospace	e Ltd
----------------	-------

	•								
W/O:		75.74	W	ORK ORDER CHANG	ES	1-11-		188	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		· · · · · · · · · · · · · · · · · · ·		***************************************					;
							·		
Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Yes	No <b>DQ</b>	<b>4:</b>	_ Date: _	#*** <u>*</u>
	Re	solution:	Disposition	on:	_ QA: N/C Cld	sed:	41-2-1	Date:	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	)	-	100 Alexandra (100 Al	
DATE	STEP	Description of NC	Description of NC Corrective Action				Verification   Approx		
	-	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	& Section C		Chief Eng	QC Inspector
		·							
		•							
							-		
							-		

₩ork	Order	ID	53781
. ,, 0	O		

November 18, 2009 12:38:42 PM



D2230-3 Accept Setup Start Item ID: F **Revision ID:** Stop Item Name: Lug Start Date: Start Qty: 120.00 18/11/2009 **Cust Item ID:** Req and Date: 25/11/2009 Req'd Qty: 120.00 **Customer:** Reference: Run Start Process Plan: Date: Tooling: Date: Approvals: Stop SPC (Y/N): Date:\_\_\_\_\_ Date: Reject Reject Set Up/ Insp. Sequence ID/ Operation Draw Draw Plan Accept Stamp Number Qty Qty Work Center ID Description Number Rev. Code Run Hours OC8- Inspect parts - second check 130 120 0.00 Memo Quality Control 0.00 140 Small Fab Small Fab Tumble and deburr rough edges after tumbling Small Fab

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Hand Finishing

Memo

0.00

W/O:			WO	RK ORDER CHANG	GES				· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	D	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		, .						শুৰু	
		·							
Part No	•	DAD #.	Fault Catao		NOD: V		204	Dut	
Part No: PAR #: Resolution:			Disposition:			· ·			
NCR:				R NON-CONFORM					
DATE	STEP	Description of NC			tion B			Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section C	Chief Eng	QC Inspector
·									
							٠		
					1	1			

Item ID:

D2230-3

F **Revision ID:** 

Item Name: Lug

Required Date: 25/11/2009

**Start Date:** 

--18/11/2009

**Start Oty: 120.00** 

Req'd Qty: 120.00



Accept



**Cust Item ID:** 

**Customer:** 

Run

Setup Start

Stop

447

1. K.

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:



Stop

Start

Sequence ID/ Work Center ID

160

QC

Quality Control

**Operation** Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours** 

Draw Draw Number Rev.

Date:

Plan Code Accept Qty

Reject Qty

Reject Insp.

Stamp Number

170

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME:

0.00

0.00

OVEN TEMPERATURE:

H09-12-7

180

Quality Control

QC3- Inspect Part Finish

Memo

0.00 => M oaliz/00

0.00

120

W/O: ् ्		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								fa					
						:		•					
Part No: PAR #			Fault Cate	egory:	NCR	: Yes	No <b>DQ</b>	<b>A</b> :	Date:				
		esolution:											
NCR:		· · · · · · · · · · · · · · · · · · ·		ER NON-CONFORM									
DATE	STEP	Description of NC Corrective Action Section					Verific	Verification App		Approval			
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector			
							į						
					+								

### Work Order ID 53781 November 18, 2009 12:38:42 PM

F

**Required Date: 25/11/2009** 

Lug



Page 4

Item ID:

D2230-3

Accept

Setup Start

Stop



**Revision ID:** Item Name:

18/11/2009

**Start Qty: 120.00** Req'd Qty: 120.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Start Date:** 

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run

Qty

QC: \_\_\_\_\_ Date: \_\_\_\_

Operation

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

190

Description

Identify as per dwg & Stock Location: 54 476

**Run Hours** 

0.00

Number Rev.

Plan Draw Code Accept Qty

Reject Reject Number

Insp. Stamp

Packaging Packaging

Memo

0.00

mo 09/11/08

Draw

1120

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			W	ORK ORDER CHANG	ES							
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
1												
		•					, e					
								i				
							ľ					
Part No: PAR #: _			Fault Cate	Fault Category: NCR: Yes No					DQA: Date:			
	Re	esolution:	Disposition	on:	_ QA: N/C C	losed:		Date: _				
NCR:			WORK ORE	ER NON-CONFORMA	NCE (NCF	₹)						
DATE	STEP	Description of NC		Ve			Approval	Approval				
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C		QC Inspector			
								,				
							,					

November 18, 2009 12:38:48 PM

Work Order ID: 53781

Parent Item:

D2230-3RevF

Parent Item Name: Lug

Comments:





Start Date: 18/11/2009

**Required Date: 25/11/2009** 

**Start Qty: 120.00** 

Required Qty: 120.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	~ .	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-3PRevF		Purchased A	no MF	09-1	2-08.	100	Each	0.0000	120.0000			
LUG D2423RevB1		Manufacture	d No			100	f	658.2039	8.6274			

Lug Extrusion

Warehouse	Loc Qty	Loc Code
<b>Location</b>		,
Main Warehouse		
ST	658.2039221	
43722	207.263091	
44529	22.39	
45800	428.550832	

8.6274 ml od/1/22

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			·					1 Tod Wigi					
	2												
				,									
							;						
Part No	•	PAR #:	Fault Cat	Fault Category: N			NCR: Yes No DQA: Date:						
		solution:											
NCR:			WORK ORE	DER NON-CONFORM	ANCE (NC	R)							
DATE	CTED	Description of NC Corrective Action			Section B Verific			Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	Section C	Chief Eng	QC Inspector				
- ·							~~~~						

DART AEROSPACE LTD	Work Order:	WLO 53781
Description: Mounting Lug	Part Number:	D2230-3
Inspection Dwg: D2230 Rev: F		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

	X First Article Prototype										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
4.450	+/-0.010	4.450									
0.413	+/-0.010	,409	1								
0.306	+/-0.010	,309									
3.700	+/-0.010	3.700									
0.750	+/-0.010	748									
Ø0.257	+0.005/-0.000	8.261									
0.375	+/-0.010	.374									
R1.200	+/-0.010	1.200	_								
0.100 x 45°	+/-0.010	,093×45°									
			·								
			-								

		1		
Measured by:	and	Audited by:	Prototype Approval:	N/A
Date:	09/12/01	Date: 09/12/04	Date:	

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	

D2230-1 D2230-3 D2230-3 MOUNTING LUG **D2230-1 MOUNTING LUG** NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ±0.005.
7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

С

nei FASEN

SHOP COPY

RETURN (\*\*)

ENGINEER\*\*\*)

UNCONTROLLED CV\*\*,

SUBJECT TO AMENDAL AL

WITHOUT NUMBER

WORK OKD. R NO. <u>5378/</u> Plog-11/8

С

	G	G REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.		09.01.16
1	F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
ı	Ε	RE-DESIGN	BW	95.01.04
ī	D	RE-DESIGN	BW	95.01.04
ī	С	RE-DESIGN	BW	94.03.30
REV.		DESCRIPTION	BY	DATE

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	11	DRAWING NO.	REV. G
MFG. APPR.	Cod.	D2230	SHEET 1 OF 3
APPROVED	KM	TITLE	SCALE
DE APPR.	<b>'-</b>	MOUNTING LUG	NTS
DATE 09.	01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS MENATE AND COMPRIMENTAL AND IS SUPPLIED OF THE SUPPLIES CHAPTION THAT IT IS NOT TO BE USED FOR ANY REPORCE OF COMPANIENCE TO ANY DIVISION PERSON WITHOUT	

2



